Work Order ID 103314

June-20-13 1:41:31 PM

ASAP

103314

PRELIMINARY ISSUE

Item ID: D4636-5
Revision ID:
Item Name: Bracket

Start Date: 6/20/13 **Start Qty:** 24.00 ~~*24* 18~~ *24* 18
Required Date: 7/04/13 **Req'd Qty:** 24.00
Reference:

Accept *N900040100*

Setup Start *NS1*
Stop *NS2*

Cust Item ID:
Customer:

Approvals: **Process Plan:** MLS **Date:** 13-06-20 **Tooling:** **Date:**
QC: **Date:** **SPC (Y/N):** **Date:**

Run Start *NR1*
Stop *NR2*

Sequence ID / Work Center ID	Operation Description	Set Up / Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr D4636 **Revision Nbr** PC2									
100	FLOW WATER JET	0.00							
100 Waterjet	**Memo**	0.00				18	ø		13-06-21
FLOW CNC Waterjet	1-Cut as per Dwg Dwg Rev: PC 2 Prog Rev: PC 2 2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110 QC	**Memo**	0.00				18	ø		13-06-21
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120 QC	**Memo**	0.00				18			
Quality Control									

13 6 21

Inspect as per Dwg PC2

DQA: ___ ___ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube	☐	Crosstube	☐	Water Jet	☐	Engineering	☐
Machining	☐	Small Fab	☐	Prod. Eng. Coor.	☐	Quality	☐
Thermoforming	☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐
Large Fab	☐	Composite	☐	Supplier	☐		☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric
- ☐ Cracks
- ☐ Crimp/Kink/Ripple/Wave
- ☐ Cuffs
- ☐ Crushing
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Marks/Chatter
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damage/Defect
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drawing
- ☐ Drill Holes
- ☐ Finish
- ☐ Fit/Function
- ☐ Folio/Program
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete/Unqualified
- ☐ Instructions Incomplete/Unclear
- ☐ Misaligned/off center
- ☐ Mislabeled
- ☐ Misread
- ☐ Off-set
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Set-up
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other _____

Work Order ID 103314

June-20-13 1:41:31 PM

103314

Item ID: D4636-5 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Bracket

Start Date: 6/20/13 **Start Qty:** 24.00 *24*

Required Date: 7/04/13 **Req'd Qty:** 24.00 *24*

Reference:

Cust Item ID:

Customer:

Approvals: **Process Plan:** _ _ _ _ **Date:** _ _ **Tooling:** _ _ _ **Date:** _ _ _ _

QC: _ _ _ _ _ **Date:** _ _ **SPC (Y/N):** _ _ **Date:** _ _

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	NC BRAKE 13 Jun 24	0.00							
130						18			13/06/24
Small Fab	**Memo**	0.00							
Small Fab	1- C'SINK HOLES AS PER DWG								
140	QC5- Inspect part completeness to step on W/O	0.00							
140						18			
QC	**Memo**	0.00							
Quality Control						Inspect as per Dwg RC2			
150	Chemical Conversion Coat per QSI005 4.1	0.00							
150						18			DAS 05 13-06-24
HandFinish	**Memo**	0.00							
Hand Finishing									

DQA: ___ ___ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
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☐ Hardware
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☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence

☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge

☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled

☐ Other _____

Work Order ID 103314

June-20-13 1:41:31 PM

103314

Item ID: D4636-5 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Bracket

Start Date: 6/20/13 **Start Qty:** 24.00 *24*
Required Date: 7/04/13 **Req'd Qty:** 24.00 *24*
Reference:

Cust Item ID:
Customer:

Approvals: **Process Plan:** **Date:** **Tooling:** **Date:** **Run Start** *NR1*
QC: **Date:** **SPC (Y/N):** **Date:** **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC7-Inspect Chemical Conversion Coat	0.00							
160 QC Quality Control	Memo	0.00							

18 x ✓ m.f 13/06/24

170	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3	0.00							
170 Powdercoat Powder Coating	Memo	0.00							
M123480	START TIME: 2-30 OVEN TEMPERATURE: 400°F FINISH TIME: 3-00								

18 x ✓ m.f 13/06/24

180	QC3- Inspect Part Finish	0.00							
180 QC Quality Control	Memo	0.00							

18 x ✓ ll 13/06/24

DQA: ___ ___ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
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☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
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General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
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☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

Work Order ID 103314

June-20-13 1:41:31 PM

103314

Item ID: D4636-5
Revision ID:
Item Name: Bracket

Accept *N900040100*

Setup Start *NS1*
Stop *NS2*

Start Date: 6/20/13 **Start Qty:** 24.00 *24*
Required Date: 7/04/13 **Req'd Qty:** 24.00 *24*
Reference:

Cust Item ID:
Customer:

Approvals: **Process Plan:** ____ **Date:** ____ **Tooling:** ____ **Date:** ____
QC: ____ **Date:** ____ **SPC (Y/N):** ____ **Date:** ____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Identify as per dwg & Stock Location: Shelves	0.00							
190 Packaging Packaging	**Memo**	0.00							
200	QC21- Final Inspection - Work Order Release	0.00							
200 QC Quality Control	**Memo**	0.00							

RD4397 – 6-13-06-25

POSITIVE RECALL
EFFECTIVE 130621 AUTH
RELEASED _____ DATE _____

DQA: ___ ___ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

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☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

Picklist Print

June-20-13 1:41:34 PM

Work Order ID: 103314

103314

Parent Item: D4636-5

D4636-5

Parent Item Name: Bracket

Start Date: 6/20/13 **Required Date:** 7/04/13

Start Qty: 24.00 **Required Qty:** 24.00

Comments: IPP REV:A 12.04.30 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.040		Purchased	No			100	sf	654.8856	0.01	0.252632			
M6061T6S.040									**	0.189		Ae	
6061-T6 .040 Sheet												13-06-21	

Location	Loc Qty	Loc Code
MAT021	654.8856	
121099	273.7156	
123874	381.17	

123874

DQA: ___ ___ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

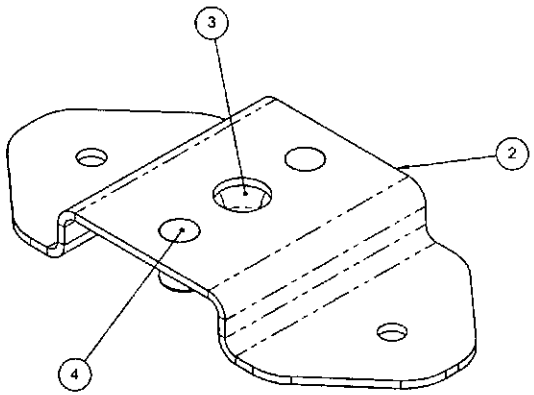
Landing Gear

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☐ Crushing
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☐ Inspection Strip in Tube
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☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

ITEM NO.	QTY. -043	PART NUMBER	DESCRIPTION
1	X	D4636-043	RECEPTACLE BRACKET ASSY
2	1	D4636-3	RECEPTACLE BRACKET
3	1	2350-18-C3Y	RIGID RECEPTACLE
4	2	MS20426AD3-2	RIVET



103314 MCJ
13-06-20

D4636-043 RECEPTACLE BRACKET ASSY PC2

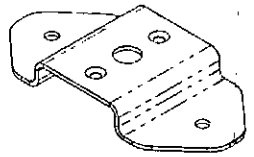
NOTES:
1) MATERIAL: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
7) WEIGHT: 0.044 lbs

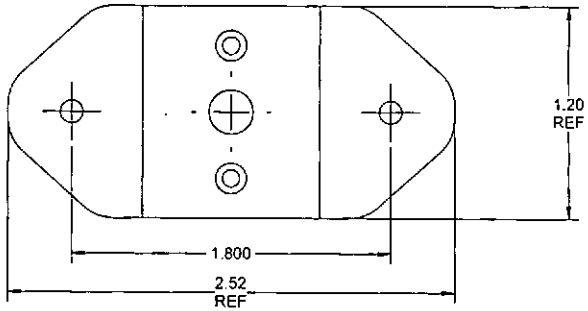
REV.	DESCRIPTION	BY	DATE
PC2	REMOVE -041/-1/-1F; REVISE D4636-043/-3 (ZN ⌀0.221 WAS ⌀0.500 (ZN C5-6)	RF	13.06.18
B	2351-20-27-ZC3T WAS 2351-20-027-Z3CT (ZN D3-1)	RF	12.11.30
A	NEW ISSUE	RF	12.07.25

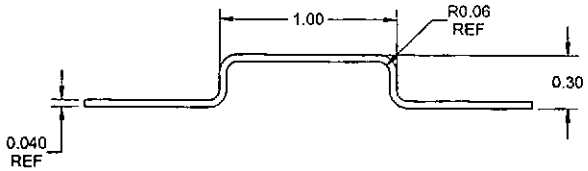
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED		DRAWING NO. D4636 — REV. PC2 — SHEET 1 OF 7
MFG. APPR.		
APPROVED		TITLE: BRACKET ASSEMBLY — SCALE: NTS
DE APPR.		
DATE	13.06.18	

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103314







D4636-3 RECEPTACLE BRACKET PC2

PRELIMINARY ISSUE

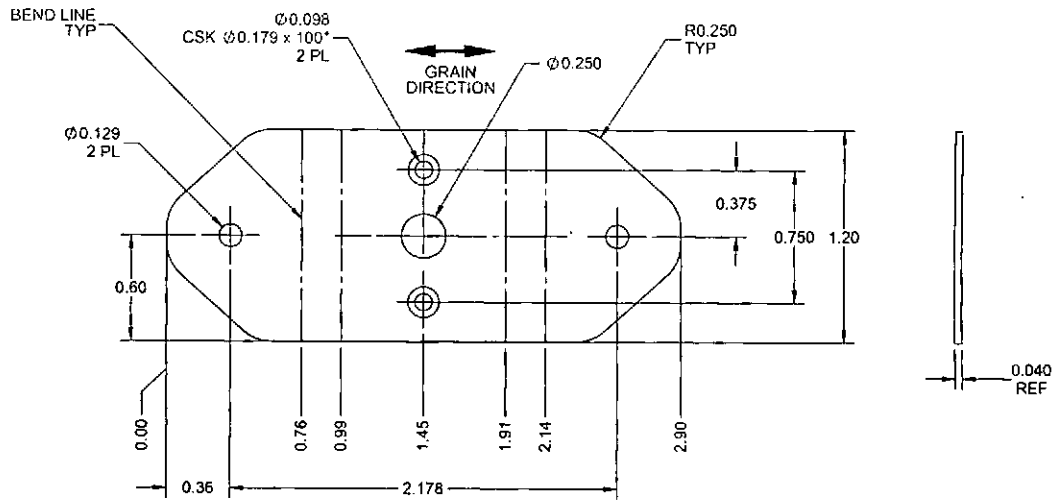
~~RF~~ 13.06.18

NOTES:
1) MATERIAL: MAKE FROM D4636-3F FLAT PATTERN
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.03 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED	~~RF~~	DRAWING NO. D4636 REV. PC2
MFG. APPR.		SHEET 2 OF 7
APPROVED		TITLE BRACKET ASSEMBLY SCALE NTS
DE APPR.		
DATE	13.06.18	

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103314



D4636-3F FLAT PATTERN RECEPTACLE BRACKET (PC2)

NOTES:
1) MATERIAL: AISI 303 SS SHEET, ANNEALED 2B FINISH
PER MIL-S-5059 OR ASTM 240 OR ASME SA240
REF DART SPEC M303S20GA
OR AISI 304/316 SS SHEET, ANNEALED 2B FINISH
PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316)
OR ASTM 240 OR ASME SA240
REF DART SPEC M304S20GA
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.03 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED		DRAWING NO. D4636 REV. PC2
MFG. APPR.		SHEET 3 OF 7
APPROVED		TITLE BRACKET ASSEMBLY SCALE NTS
DE APPR.		
DATE	13.06.18	

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DART AEROSPACE LTD	Work Order:	103314
Description: BRACKET	Part Number:	~~103314~~ 4636-5
Inspection Dwg: 4636 Rev: PC2		Page 1 of 1

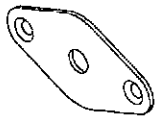
FIRST ARTICLE INSPECTION CHECKLIST

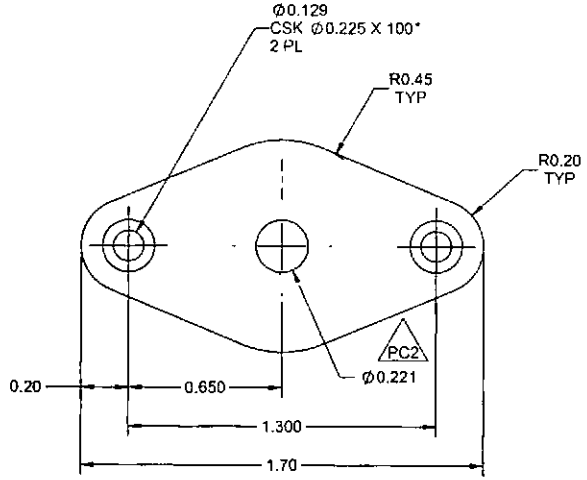
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
∅ 0.129	+.004 -.001	0.133	-		V	JKm-01
∅ 0.221	+0.005 -.001	.225	-		V	JKm-01
.20	+/- 0.030	.20	-		V	
.650	+/- 0.010	.650	-		V	
1.300	+/-0.010	1.30	-		V	
1.70	+/- 0.030	1.69	-		V	
R0.45	+/- 0.030	.45	-		RG	
R0.20	+/- .030	.20	-		RG	
0.040	+/- ~~0.039~~	.039	-		V	JKm-01

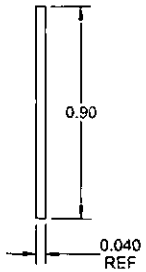
Measured by:	Ae	Audited by:		Preliminary Approval:	
Date:	13-06-21	Date:	13-6-21	Date:	

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15







D4636-5 BRACKET

PRELIMINARY ISSUE

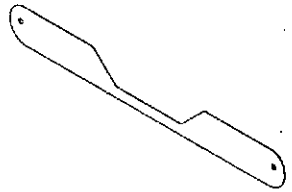
RF 13.06.18

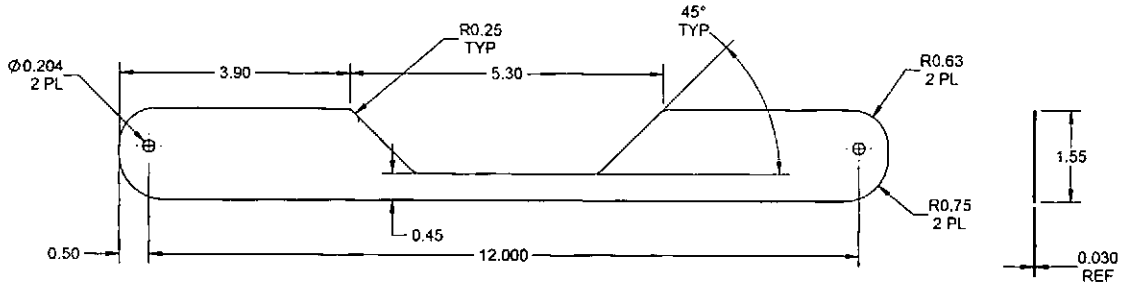
NOTES:
1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.040
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
7) WEIGHT: 0.00 lbs

DESIGN	RF	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	DRAWING NO. D4636 REV. PC2
CHECKED	RF	SHEET 4 OF 7
MFG. APPR.		TITLE BRACKET ASSEMBLY SCALE NTS
APPROVED		
DE APPR.		
DATE	13.06.18	

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103314





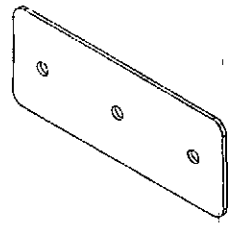
D4636-7 RETAINER PLATE

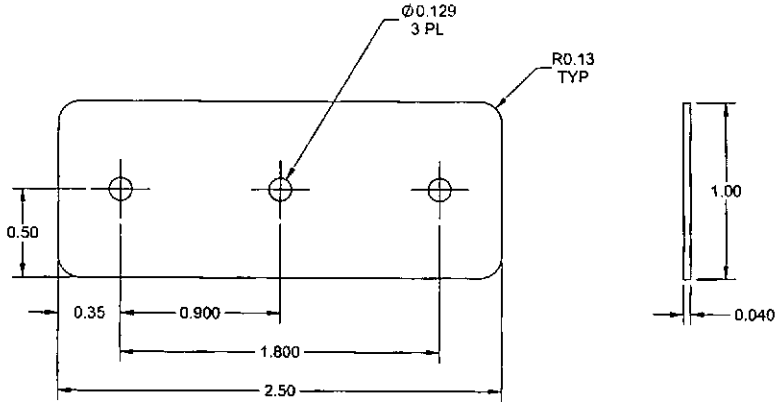
NOTES:
1) MATERIAL: AISI 303 SS SHEET, ANNEALED 2B FINISH
PER MIL-S-5059 OR ASTM 240 OR ASME SA240
REF DART SPEC M303S22GA
OR AISI 304/316 SS SHEET, ANNEALED 2B FINISH
PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316)
OR ASTM 240 OR ASME SA240
REF DART SPEC M304S22GA
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
7) WEIGHT: 0.13 lbs

PRELIMINARY ISSUE
RF 13.06.18

DESIGN	RF	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED		DRAWING NO. D4636 REV. PC2 SHEET 5 OF 7
MFG. APPR.		
APPROVED		TITLE BRACKET ASSEMBLY SCALE NTS
DE APPR.		
DATE	13.06.18	

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D4636-9 TEMPLATE

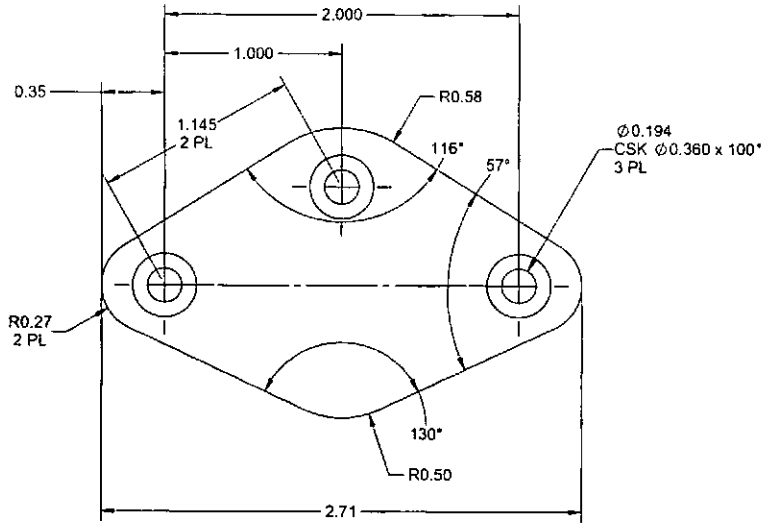
NOTES:
1) MATERIAL: AISI 303 SS SHEET, ANNEALED 2B FINISH
PER MIL-S-5059 OR ASTM 240 OR ASME SA240
REF DART SPEC M303S20GA
OR AISI 304/316 SS SHEET, ANNEALED 2B FINISH
PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316)
OR ASTM 240 OR ASME SA240
REF DART SPEC M304S20GA
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
7) WEIGHT: 0.03 lbs

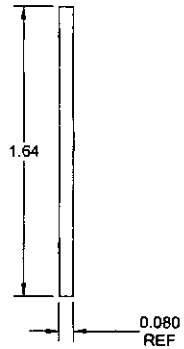
PRELIMINARY ISSUE
RF 13.06.18

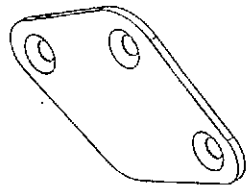
DESIGN	RF	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED	[illegible]	DRAWING NO. D4636 REV. PC2 SHEET 6 OF 7
MFG. APPR.		
APPROVED		TITLE BRACKET ASSEMBLY SCALE NTS
DE APPR.		
DATE	13.06.18	

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10331Y







D4636-11 BRACKET

NOTES:
1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.080
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
7) WEIGHT: 0.02 lbs

PRELIMINARY ISSUE

RF 13.06.18

DESIGN	RF	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. PC2
MFG. APPR.		D4636	SHEET 7 OF 7
APPROVED		TITLE	SCALE
DE APPR.		BRACKET ASSEMBLY	NTS
DATE	13.06.18		

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Receiving Report

Date: 12/4/09

Batch No: [redacted]

Supplier: CAMP1

Dart P/O: 18480

Packing Slip: Yes ✓ No ___
Invoice: Yes ___ No ✓
Receipt: Cash ___ Cr ✓

Release Note Attached: Yes ✓ No ___ N/A ___
Waybill Attached: Yes ___ No ✓
Shipment Complete: Yes ✓ No ___ N/A ___
QC6 Inspection ✓ DAS 16 8-09 N/A ___
Work Order 12/4/09 N/A ✓

Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments

Initials of receiver (if shipment OK) Level 12 ✓

Production/Admin: Date Received/Costing Initial 12/4/09

Location ___

H:\FORMS\Purchasing\approved purch\RECREPORT Rev D

Purchase Order Receipt Listing

Thursday, November 29, 2012 3:28:44 PM

All amounts are calculated in domestic currency.

All Vendors PO ID PO18480 Receipt Dates from 11/29/2012 to 11/29/2012 All Line Item Types
All Item ID/GL/WOs All Rec. Employees All Currencies
Grouped by Vendor ID

Purchase Order ID/ Curr Type	Line Nbr/ Insp Req	Project ID	Reference/ Description/ Cert Std	PO U/M / Stock U/M	Required Date Required Qty	Recv Date/ Recv Emp	Recv Qty (PO U/M)	Cost Per Unit/ Recv Value	Inspected Qty/ Rejected Qty (PO U/M)	MRB Qty/ MRB Reject Qty	Book Amt
VendorID\Vendor Name			**VC-CAM002 Campi Steel**								
PO18480	1		M6061T6S.040	sf	11/28/2012	11/29/2012	624.0000	$2.42	0.0000	0	$1,509.51
CAD	No		6061-T6 .040 Sheet 123874	sf	624.0000	DESJ02		$1,509.51	0.0000	0	

Total Received Quantity:	624.0000
Total Qty to Inspect (PO U/M):	0.0000
Total Reject Quantity:	0.0000
Total Receipt Value:	$1,509.52
Total Balance Due Quantity:	0.0000

CAMPI
935, boul. du Havre
Valleyfield (Québec)
J6S 5L1

TÉLÉPHONE : 450 377-4248
FAX : 450 377-5696

MONTRÉAL : 514 336-4248
FAX : 514 336-4246

ONTARIO : 1 800 667-4248
FAX : 1 866 456-4242

DISTRIBUTEUR D'ACIER ET M... SPÉCIALISÉS
STEEL AND SPECIALTY METALS DISTRIBUTOR

On a du Savoir " FER "

29388

VENDU À / SOLD TO:	EXPÉDIEZ À / SHIP TO: SKID
613-632-5200 613-632-1053	
DART AEROSPACE LTD 1270 ABERDEEN STREET HAWKESBURY, ONTARIO K6A 1K7 EQUIP:DUI LIFT	DART AEROSPACE LTD 1270 ABERDEEN STREET HAWKESBURY, ONTARIO K6A 1K7

COMMANDE / ORDER N° 200356

DATE 22/11/12

BON DE LIVRAISON / PACKING SLIP N°

DATE DE LIVRAISON / DELIVERY DATE 29/11/12

VOTRE N° DE COMMANDE / YOUR P.O. N°	VEND. / SALESM.	CODE CLIENT / CUST. CODE	EXPÉDIÉ PAR / SHIP VIA	TERMES / TERMS	TERR.	REMARQUES / REMARKS	PAGE N°
18480	JB	DAER		NET 30 JOURS	2R		001

CODE DE PRODUIT / PRODUCT CODE	COMMANDÉ / ORDERED	EXPÉDIÉ / SHIPPED	DESCRIPTION	POIDS / WEIGHT	PRIX / PRICE	PAR / PER *	MONTANT / AMOUNT
	13	13x4x12	AL*TUBE .040 6061T6 13 X 4'=X' 12" SUR SKID Heat: H a688024	13.00			

* Unités de mesure / Units of measure : CLB Cent livres / Hundred pounds • CPI Cent pieds / Hundred feet • UN Unité / Unit • PI Pied / Foot • PC Pied carré / Square foot

POIDS TOTAL / TOTAL WEIGHT 13

SOUS-TOTAL / SUB TOTAL

T.P.S. / G.S.T.

T.V.Q. / T.V.H. / Q.S.T. / H.S.T.

TOTAL

CONDITIONS :

LES MATÉRIAUX LIVRÉS ET FACTURÉS TELS QUE DÉCRITS DEMEURENT LA PROPRIÉTÉ DE "ACIER CAMPI INC." JUSQU'À PARFAIT PAIEMENT COMPLET. L'ACHETEUR ENGAGE À LES RISQUES DE PERTES OU BIEN SONT À LA CHARGE DE L'ACHETEUR. LA GARANTIE DE QUALITÉ DU MATÉRIEL EST LA MÊME QUE CELLE DU FABRIQUANT. L'ACHETEUR S'ENGAGE À RESPECTER LES CONDITIONS SUIVANTES : NET 30 JOURS DE LA DATE DE FACTURATION ET TOUT COMPTE IMPAYÉ DANS LES 30 JOURS ENTRAÎNE DES FRAIS DE 2% PAR MOIS (24% PAR AN) EN DUS. ACCEPTE DE PAYER : TOUT DÉFAUT D'EXÉCUTER LIVRE OU AUTRE DES OBLIGATIONS EN VERTU DU PRÉSENT CONTRAT ENTRAÎNE LA DÉCHÉANCE DU TERME ET PERMET AU VENDEUR À SON CHOIX DE RÉCLAMER TOUT SOLDE DU PRIX DE VENTE OU REPRENDRE LE BIEN VENDU. TOUTE RÉCLAMATION DOIT ÊTRE FAITE DANS LES CINQ JOURS SUR PRÉSENTATION DE CE DOCUMENT. TOUTE MARCHANDISE ENDOMMAGÉE, ALTÉRÉE OU COUPÉE NE PEUT ÊTRE REMPLACÉE. AUCUN RETOUR DE MARCHANDISE NE SERA ACCEPTÉ SANS NOTRE AUTORISATION. TOUTE MARCHANDISE RETOURNÉE EST SUJETTE À DES FRAIS DE MANUTENTION DE 25%.

CONDITIONS :

ALL SOLD AND DELIVERED MATERIALS REMAIN THE PROPERTY OF "ACIER CAMPI INC." UNTIL PAYMENT IS MADE IN FULL, COMPLETE AND CASHED. ALL LOST MATERIALS ARE AT THE BUYER'S EXPENSE. ALL MATERIALS BEAR THE SAME WARRANTY AS GIVEN BY THE MANUFACTURER. THE BUYER HEREBY ACCEPTS TO RESPECT THE FOLLOWING CONDITIONS : NET 30 DAYS FROM BILLING DATE AND THE BUYER ACCEPTS TO PAY ADMINISTRATION CHARGES OF 2% PER MONTH, OR 24% PER ANNUM ON ALL PAST DUE ACCOUNTS OVER 30 DAYS. ANY DEFAULT IN RESPECT WITH THIS CONTRACT WILL LEAD TO PAYMENT BY ACCELERATION AND PERMITS TO THE SELLER, AT HIS CHOICE TO CLAIM FOR THE BALANCE DUE OR THE REPOSSESSION OF THE GOODS SOLD. ANY CLAIM MUST BE MADE WITHIN FIVE DAYS WITH THIS DOCUMENT ENCLOSED. ANY MERCHANDISE THAT HAS BEEN DAMAGED, CUT OR MODIFIED CAN NOT BE RETURNED. ALL GOODS RETURNED MUST BE WITH OUR AUTHORIZATION AND ARE SUBJECT TO A 25% RESTOCKING CHARGE.

PRÉPARÉ / PREPARED.	VÉRIFIÉ / VERIFIED	LIVRÉ / DELIVERED	HEURE / TIME
PAR / BY	PAR / BY MM	PAR / BY MB	11 30

MARCHANDISE REÇUE EN BONNE CONDITION / MERCHANDISE RECEIVED IN GOOD CONDITION

X _____ A/Y 12 M/M 11 J/D

SIGNATURE DU CLIENT / CUSTOMER'S SIGNATURE DATE

N° ENR. TPS / GST REG. N° R 135 534 717 N° ENR. TVQ / QST REG. N° 1015 668 543

CERTIFIED INSPECTION REPORT

Alcoa Inc. DAVENPORT WORKS 4879 State Street Bettendorf, IA 52722

Ship From: RIVERDALE, IA.

We hereby certify that the material covered by this certificate has been inspected with, and has been found to meet the applicable requirements described therein. Including any specifications forming a part of the description and that samples representative of the material met the composition limits and had the mechanical properties shown on the face of this sheet.

This test report shall not be reproduced except in full, without the written approval of the Quality Department. No alteration, addition or other change is authorized to be made to this certificate. The recording of false, fictitious , or otherwise fraudulent statements or entries on this certificate by any recipient may be punished as a felony under applicable law.

Per,

Rob Woodall
Director of Manufacturing Davenport Works

Terrance Thon
Quality Assurance Manager

1403721 0

Ship Date	B.L. No.	Invoice No.	Alcoa No. Item	
2012-07-12	7184256	00000	1000374585-2	DPE-74585-2

P.O. No./Govt Contract No.	Customer	Alcoa Item
C65127 Ln#: 2		

Ship To:

R1480

Item Description
0.064 IN TK (+0.0000 -.0035) X 48.0 IN W (+.125 -.125) X 144.0 IN LN (+.15625 -.15625) (N) A/T 6061-T6 FLAT SHEET FOR DISTRIBUTORS TOLERANCE GUARANTEED TO AMS4027 REV N EXC MRK ASTMB209 REV 10 CMMP025 REV U ((MARKED)) KRAFT PAPER INTERLEAVED MAX GROSS SKID WGT: 4500 LB QUAN TOL +/- 30 % CQR 0225054 REV 03 CUST REQ 12-06-30 *** N/E 12-07-14 ***

Num	Package Ticket	Lot	Weight	Quantity	UOM	Inspector Clock Numbers
1	429448	S22771	4085	160	PC	27847 47360 DCU39438
2	429449	S22771	4148	160	PC	27847 47360 DCU39440
3	429451	S22771	155	6	PC	27847 47360 DCU39441
4	429458	S22771	4093	160	PC	27847 47360 DCU39442
5	429459	S22771	501	20	PC	27847 47360 DCU39443
			12963	506		

Notes for CQR: 0225054.3

PRODUCT PRODUCED TO THE REQUIREMENTS OF AMS4027 REV N ALSO MEET THE REQUIREMENTS OF AMS-QQ-A-250_11 ORIGINAL REVISIO N DATED 1997-08-01.

CQR: 0225054.3 -Specification Limits

Tmpr	Dir		UTS KSI	TYS KSI	EL4D PCT
T6	Long Transv.	Max			
		Min	42.0	35.0	10

CERTIFIED INSPECTION REPORT

Alcoa Inc. DAVENPORT WORKS 4879 State Street Bettendorf, IA 52722

Ship From: RIVERDALB, IA.

We hereby certify that the material covered by this certificate has been inspected with, and has been found to meet the applicable requirements described thereon including any specifications forming a part of the description and that samples representative of the material met the composition limits and had the mechanical properties shown on the face of this sheet.

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Per

Rob Woodall
Director of Manufacturing Davenport Works

Terrance Thom
Quality Assurance Manager

1403721	0			
Ship Date	B.L. No.	Invoice No.	Alcoa No. Item	
2012-07-12	7184256	00000	1000374585-2	DPE-74585-2

P.O. No./Govt Contract No. Customer Alcoa Item

C65127 Ln#: 2

CQR: 0225054.3 -Specification Limits (cont.)

Chemical Composition		SI	FE	CU	MN	MG	CR	ZN	TI	Other Each	Other Total	Aluminum
	Max	0.8	0.7	0.40	0.15	1.2	0.35	0.25	0.15	0.05	0.15	
Alloy 6061	Min	0.40		0.15		0.8	0.04					REMAIN

Lot: 522771 - Mechanical, Physical, Metallography, Quantometer Results

Tmpr	Dir	No->	UTS	TYS	EL4D
		Test	KSI	KSI	PCT
T6	Long Transv.	7	50.4	42.5	13.6
			50.4	42.6	12.9
			50.3	42.6	13.3
			50.4	42.6	12.8
			50.3	42.4	12.9
			50.5	42.5	13.2
			50.5	42.5	13

Cast Number	Chemical - OES	SI	FE	CU	MN	MG	CR	ZN	TI
M2088024	Actuals	0.65	0.4	0.23	0.07	1.0	0.16	0.02	0.03

This material was melted in the United States or a Qualifying Country [REF DFARS 225.872.1(a)]; it was manufactured in the United States

Chantal Lavoie

From: Joann C <vente@aciercampi.com>
Sent: November 29, 2012 11:42 AM
To: 'Chantal Lavoie'
Subject: MILL TEST
Attachments: DART18480.pdf

Bonjour Chantal,

Voici le mill test pour votre commande # 18480, le heat est H2088024.

Merci
Joann

DART aerospace

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO18480

Purchase Order Date 11/22/12
PO Print Date 11/22/12

Order From : VC-CAM002

CAMPI STEEL
935 BOUL. DU HAVRE
VALLEYFIELD, QC J6S 5L1
CA

Contact Name		**Buyer**	Chantal Lavoie
Vendor Phone	800 667 4248	**Requisition Nbr**	
Vendor Fax	450 377 5696	**Tax Resale Nbr**	10127-2607
Vendor Account Nbr		**Terms**	Net 30
		Currency	CAD
		FOB	Destination-Collect

Ship To : DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FAXED

Line Nbr	Reference / Revision ID / Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	M6061T6S.040	6061-T6 .040 Sheet	11/28/12 Yes	288.00 sf	Yours ppd	$2.4167	$696.00

624 11/11/59

Special Inst: MATERIAL: 6061-T6/T62 ALUMINUM SHEET
AS PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 40327 OR ASTM B209

PO Total: **$696.00**

MATERIAL CERTIFICATION REQ'D UPON DELIVERY

No substitution or deviation without consent.
Certificate of Conformity or Material Certification required (YES) NO

Change Nbr: 1 **Change Date:** 11/22/12